

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.yy**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000340**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 12-Oct-2007**Location:** Changxing Island, Shanghai, China**Submittals(New / Total):****CWR's:** /**HSR's:** /**NCR's:** /

Item	Title	Detail
1	Key conversations	At 07:30 I informed ABF's Steve Lawton about the resolution to the outstanding issues from the previous day's ZPMC Daily Meeting. ABF was informed that the material lists that were not provided and reviewed under RFI-786R02 may be submitted for acceptance. ABF was informed that the Q235 material referenced in RFI-556R00 may be submitted for acceptance for the tower mock-up provided that the chemical analysis of the material was in conformance.
2	Key conversations	At 08:15 ABF cancelled today's scheduled inspection to check joint geometry of closed ribs for the upcoming weld trial. The inspection is to be rescheduled for Monday, 15-Oct-07. ABF stated that the inspection was rescheduled because the dimensions of the closed ribs had not previously been verified. ABF understood that ZPMC intended to use closed ribs formed during the closed rib bend demonstration for the weld trials. The closed ribs that ZPMC had prepared for the weld trials were formed independently by ZPMC after the bend demonstration, and the dimensions of these had not been verified.
3	Other important observations	I conducted a shop floor walkthrough at approximately 08:45 today. ZPMC was observed preparing closed ribs for the closed rib weld trials that are to begin on Monday, 15-Oct-07. ZPMC was observed performing dimensional checks of the closed ribs that they intended to use for the weld trials. ZPMC informed CT that the closed ribs did not meet dimensional tolerances and that ZPMC will not use these for the weld trials.

ZPMC was observed grinding the root faces of closed ribs that are to be used for the weld trials. CT asked ABF if grinding of the root faces is part of ZPMC's fabrication procedures. ABF stated that the grinding was being performed in order to remove rust that had collected on the closed ribs. ABF stated that the grinding was only being performed for the weld trial and will not be done in production. CT expressed that the root face, which is affected by the grinding, may be a factor in the weld trials. CT stated that

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the difference between the closed rib preparation for the weld trials and the fabrication procedures will be noted.

ZPMC was observed performing splice welding of skin plates for the 89-m tower mock-up section. ZPMC was observed practicing performance of longitudinal stiffener to skin plate CJP welds.

OBG bottom panel shop floor was not prepared for fabrication.

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4 Meetings attended

The ZPMC Daily Meeting was conducted at 13:00 today. ZPMC asked if it would be acceptable to grind the diaphragm plate in order to get the bent flange plates to fit. CT took no exception to ZPMC's means and methods. CT asked ABF if they could provide a date of the purchase order for incoming material in order to check which MTRs required fine grain size. ABF is researching that issue. ABF informed us that ZPMC will be performing a second demonstration of the floorbeam intersecting welds.

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5 Key conversations

I informed Gang Jiao at approximately 17:30 that CT was satisfied with the first floorbeam intersecting weld demonstration and that a second demonstration is unnecessary.

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**Inspected By:** Velasco, Abifhram

Quality Assurance Inspector

**Reviewed By:** Lowry, Patrick

QA Reviewer

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